

Date: Wednesday, 06/05/2009 8:51:35 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARPAW
Job Number : 47761	
Estimate Number : 11648	
P.O. Number :	Part Number : D2996
This Issue : 06/05/2009 S.O. No. :	Drawing Number : D2996 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A1
Previous Run :	Material :
Written By :	Due Date : 13/05/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JLD 09.05.09</u>	
Comment : Est A 01.03.07 New Issue EC	
Est Rev:B New Manufacturing Process 08-11-15 JLM Verified	
By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MFG ENGINEERING	MFG ENGINEERING
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Comment: MFG ENGINEERING
 Program Batch number

J.F.S 09/05/07

2.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 2.7777 sf(s)/Unit Total : 16.6662 sf(s)
 Pick:
 Material: Black UHMW 1"
 Batch 111354 B 9-5-11

6

3.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 CUT BLANK AS PER FILE D2996

B 9-5-11

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Inspect material for defects or damage prior to machining
 Machine as per folio FA120
 Deburr

DFO 7

SS 09/05/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2996 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/05/13
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>47761</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09.05.13</u>	<u>4</u>	<u>0.06x45° CHAMFER 15 0.120x45° IN AFT CORNER. PART LIFTED DURING MACHINING</u>	<u>CP</u> <u>09.05.13</u> <u>per</u> <u>QSI 042</u>	<u>Acceptable</u>	<u>28</u> <u>09/05/13</u>	<u>S</u> <u>09/05/13</u>	<u>CP</u> <u>09.05.13</u> <u>per</u> <u>QSI 042</u>	<u>S</u> <u>09/05/13</u>
		<u>R.C. Process</u>						

NOTE: Date & initial all entries

Date: Wednesday, 06/05/2009 8:51:36 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW

Job Number: 47761

Part Number: D2996

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

88 09/05/13

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MF 09-05-15

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O 48076 D## D600-572-015

MF 09-05-20

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/20

Job Completion



MF 09-05-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47761
Description: BEARPAW		Part Number: D2996
Inspection Dwg: D2996 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

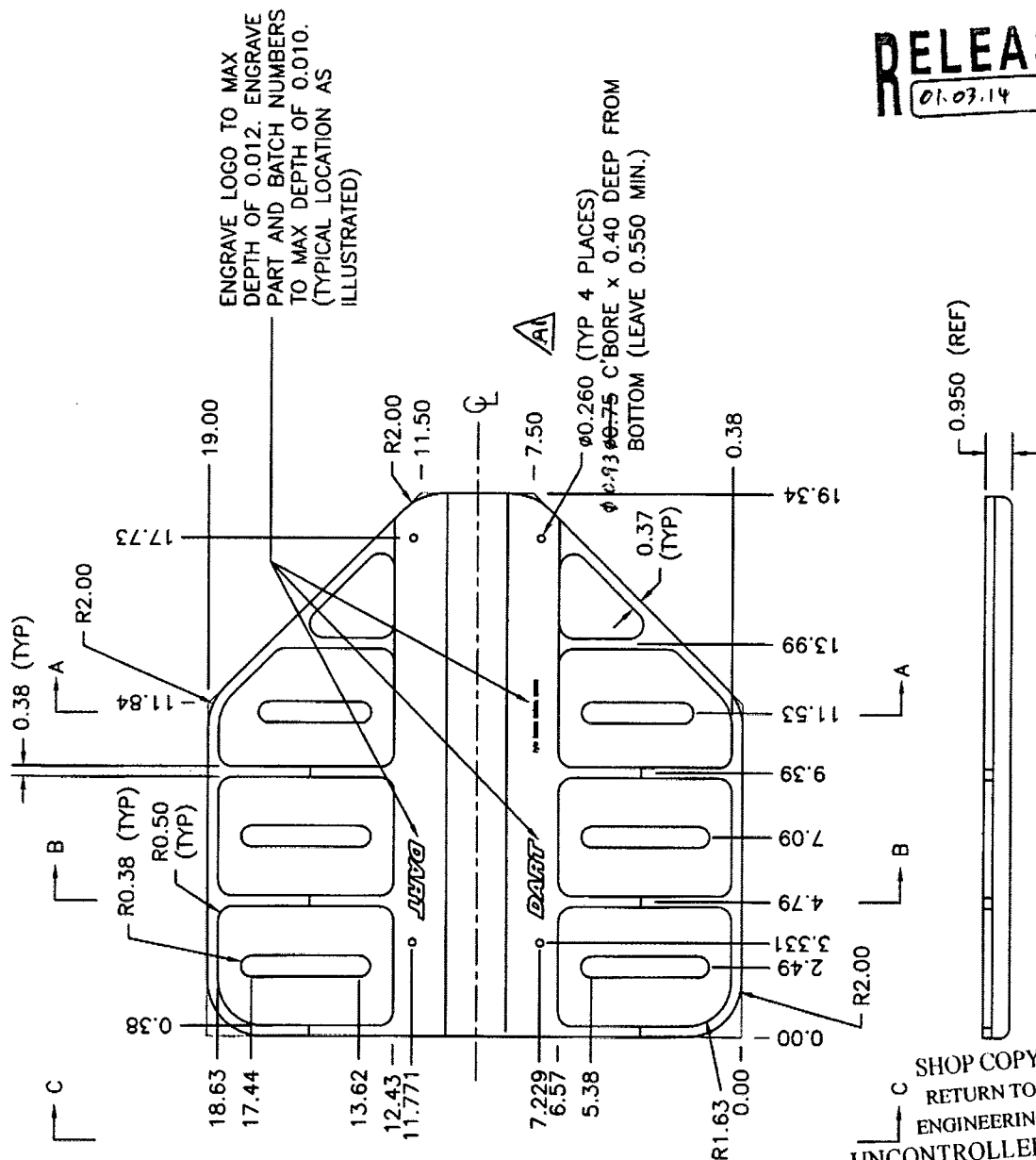
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.625	$\pm .010$.628	✓			
.250	$\pm .010$.251	✓			
R0.250	$\pm .030$.250	✓			
.250 X 45°	$\pm .030 \times 0.5^\circ$.250	✓			
5.86	$\pm .030$	5.867	✓			
0.950	$\pm .010$.953	✓			
.433	$\pm .010$.438	✓			
19.00	$\pm .030$	19.00	✓			
4.540	$\pm .030$	4.552	✓			
3.630	$\pm .030$	3.618	✓			
7.229	$\pm .010$	7.236	✓			
11.771	$\pm .010$	11.780	✓			
.38	$\pm .030$.375	✓			
3.331	$\pm .010$	3.335	✓			
17.73	$\pm .030$	17.73	✓			
19.34	$\pm .030$	19.34	✓			
Ø.260	$\pm .006 - .001$.259	✓			
.300	$\pm .030 - 0.00$.317	✓			
.930	$\pm .030$.925	✓			

Measured by: <i>SP</i>	Audited by: <i>[Signature]</i>	Prototype Approval: <i>1/A</i>
Date: 09/05/13	Date: 09.05.15	Date: <i>1/A</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	✓	APPROVED	✓	DRAWING NO. D2996
				REV. A SHEET 1 OF 2
DATE	01.02.23	TITLE	BEARPAW	SCALE 1:6
A	01.02.23	NEW ISSUE		
A1	✓ 03.01.13	φ0.93 WAS φ0.75		

RELEASED
01.03.14

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4776

BEARPAW IS SYMMETRIC ABOUT CENTERLINE (EXCEPT FOR ENGRAVING)
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

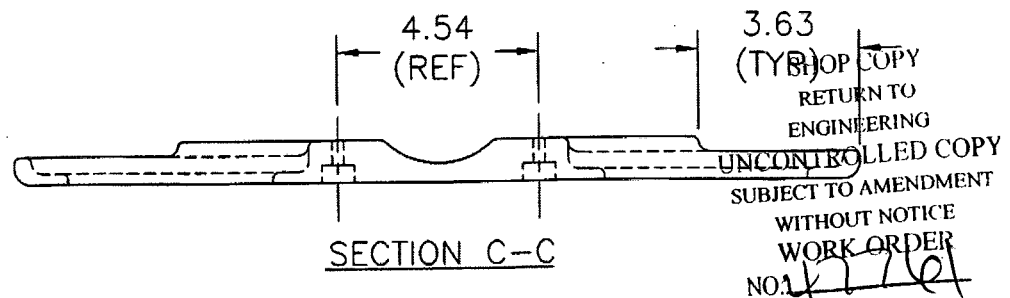
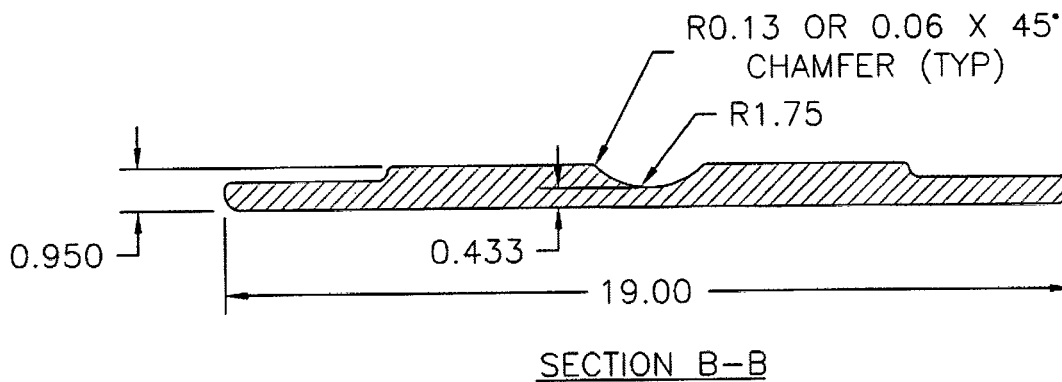
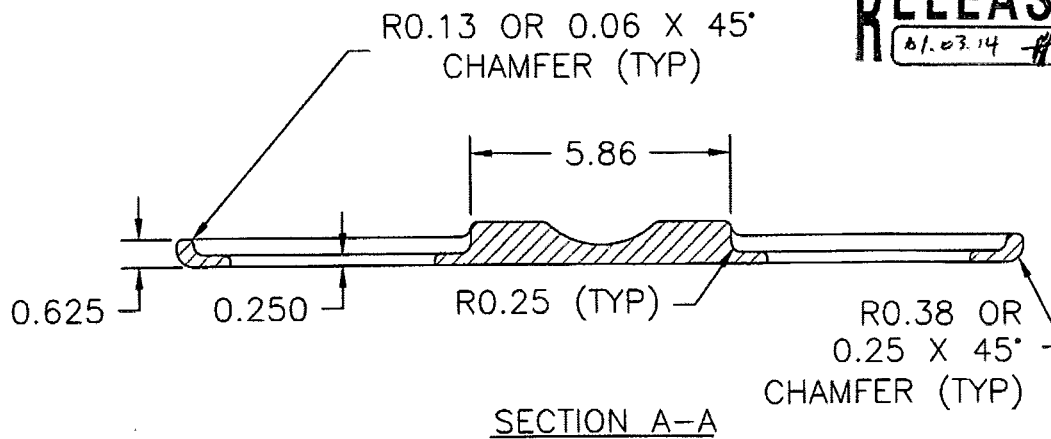
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2996	REV. A SHEET 2 OF 2
DATE 01.02.23		TITLE BEARPAW	SCALE 1:4

RELEASED
01.03.14 #

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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